

# Work Order ID 101759

**\*101759\***

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May-15-13 9:49:00 AM

Item ID: D2809 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bushing  
 Start Date: 03/06/2013 Start Qty: 24.00 **\*24\*** Cust Item ID:  
 Required Date: 03/06/2013 Req'd Qty: 24.00 **\*24\*** Customer:  
 Reference: *C/M 1305-15*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2809	Rev A1								
100	Hardinge CNC LATHE SMALL	0.00				<u>24</u>	<u>0</u>		<del>DAS</del> 04 2-83
<b>*100*</b>									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Machine as per Folio FA204	<i>SA 13-5-15</i>							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				<u>24</u>	<u>0</u>		
<b>*110*</b>									
QC	Memo	0.00							
Quality Control		<i>SA 13-5-15</i>							
120	QC8- Inspect parts - second check	0.00				<u>24</u>	<u>0</u>		<del>DAS</del> 04 2-83
<b>*120*</b>									
QC	Memo	0.00							
Quality Control		<i>13-5-15</i>							

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\*101759\*

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Item ID: D2809 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bushing  
 Start Date: 03/06/2013 Start Qty: 24.00 \*24\* Cust Item ID:  
 Required Date: 03/06/2013 Req'd Qty: 24.00 \*24\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	Chemical Conversion Coat per QSI005 4.1	0.00							
*125*									
HandFinish	Memo	0.00							
Hand Finishing									
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*130*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:30								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 2:00								
160	QC3- Inspect Part Finish	0.00							
*160*									
QC	Memo	0.00							
Quality Control									

24 x d 12/05/15

24 x d m 13/05/16

24 x d 13/05/16

M125620

**\*101759\***

May-15-13 9:49:00 AM

**Accept**

**\*N900040100\***

Setup Start **\*NS1\***

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 03/06/2013    **Start Qty:** 24.00

**\*24\***

**Required Date: 03/06/2013      Req'd Qty: 24.00**

\*24\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

Identify as per dwg & Stock Location: C 7

0.00

**\*170\***

### Packaging

## Memo

0.00

## Packaging

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

MLJ 13-05-17

# Picklist Print

May-15-13 9:48:58 AM

Page 1

Work Order ID: 101759

Parent Item: D2809

Parent Item Name: Bushing

Start Date: 03/06/2013

Required Date: 03/06/2013

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C02.03.07Now turned in houseNG IPP REV:D 11.12.08 added powdercoat per dwg DD  
VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased	No			100	f	118.7060	0.0995	2.5136832			
.6061-T6 Round Bar .500"													

Location

Loc Qty

Loc Code

MAT012

118.706

114488

3.994

123483

1.238

124029

3.474

124681

50

125552

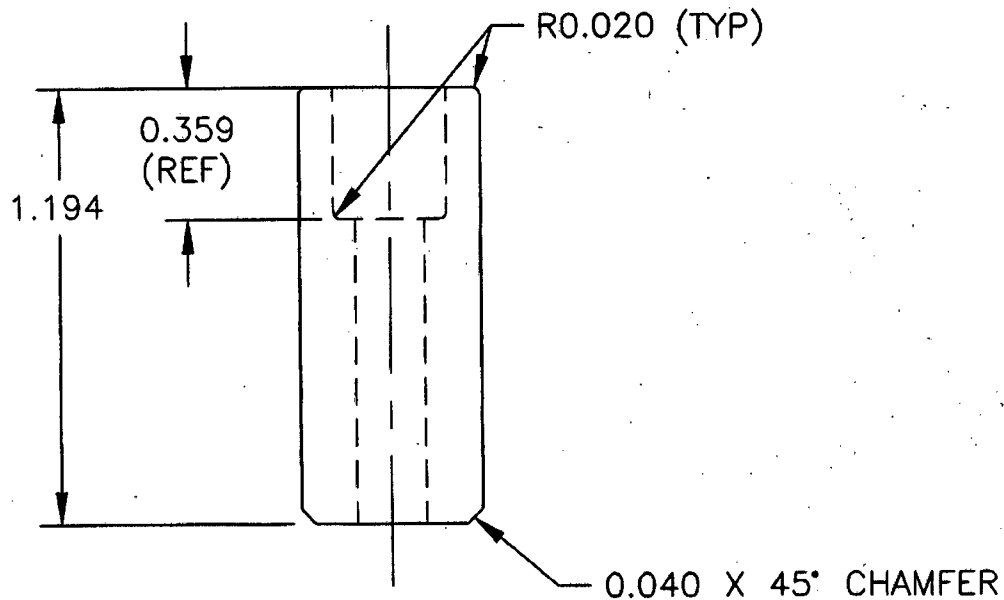
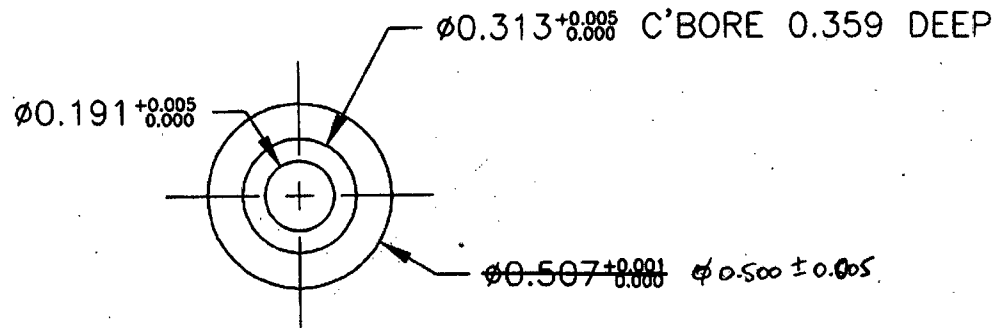
60

2.8 Lt

5/1 13-5-13

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	01.04.26	ADD POWDER COAT; $\phi 0.500$ WAS $\phi 0.507$	

**RELEASED**  
00.11.13

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020

MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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PER DART QSI 005 4.3

